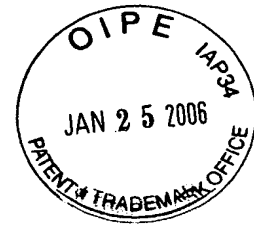


Appln. No. 10/725,410
Amdt. dated January 25, 2006
Reply to Office Action of January 31, 2005
REPLACEMENT ABSTRACT



ABSTRACT OF THE DISCLOSURE

An internal broach for internally broaching profiles, defined by a bottom and flanks, of female serrations of a work piece having a toothed section with several rows of broach cutting teeth, the rows being disposed successively counter to a direction of broaching, with successive broach cutting teeth being allocated to each other for broaching a profile. The broach cutting teeth have bottom cutting blades and first and second sides. The first sides are guide flanks, the edges of which are guide edges without cutting ability. The second sides are relieved flanks, the edges of which are relieved edges without cutting ability.